

# Work Order ID 57294

Wednesday, March 31, 2010 3:41:19 PM



Page 1

Item ID: D4035-047

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Aft (Light)

Stop



Start Date: 3/31/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 4/5/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-3-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R Aluminum rod Batch: 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

> m-l 10/04/02  
EL 10-4-5 (x2)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

PD 10.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4035-047 PAR #: \_\_\_\_\_ Fault Category: Small Fabs NCR: (Yes) No DQA: \_\_\_\_\_ Date: 10/04/06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/04/12



NCR: <u>57294</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/06</u>	<u>th</u> <u>100</u>	<u>.375" holes were drilled off</u> <u>center. Parts were done</u> <u>on the drill press.</u> <u>EC employee didn't know</u> <u>about the Drill Sg. LPA.</u>	<u>[Signature]</u>	<u>Scrap + destroy Qty +1</u> <u>Replce M 103069</u>	<u>10/04/06</u> <u>M-H</u>	<u>S</u> <u>10/04/06</u>	<u>[Signature]</u>	<u>S</u> <u>10/04/06</u>
			<u>[Signature]</u>	<u>[Diagonal Line]</u>	<u>[Diagonal Line]</u>	<u>[Diagonal Line]</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10/04/06</u>



NOTE: Date & initial all entries







# Work Order ID 57294

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Item ID:	D4035-047	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Rib Assembly, Aft (Light)				Stop	
Start Date:	3/31/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	4/5/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	5.06.06.06						
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>Back of</u>  Memo	0.00  0.00					PD 10.04.06		
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				<div>10/04/07</div> <div>mf</div> <div>10-4-6</div>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 31, 2010 3:41:19 PM

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Work Order ID: 57294

Parent Item: D4035-047

Parent Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 3/31/2010

Required Date: 4/5/2010

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4035-11		Manufactured	No			100	Each	8.0000	4.0000			



Bushing

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST109

56958 ✓

8

8

M6061T6TS0.750W.06  
2

Purchased

No

100

f

165.1568

3.9474



6061-T6 SQ Tube .75 x .75 x .062W



Warehouse Loc Qty Loc Code  
Location

Main Warehouse

MAT06

103069 ✓

104422

16441

9671 ✓

165.1568

51.0968

69.75

10.31

34

4X M-L  
10/04/02

1.9737

1.9737

M-L  
10/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

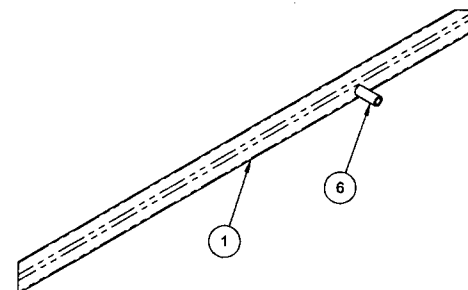
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

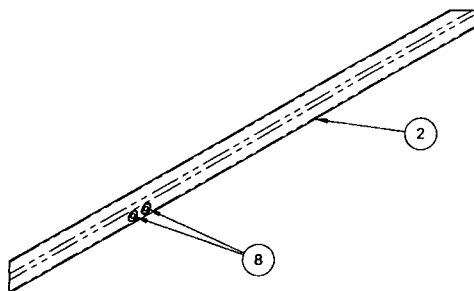
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

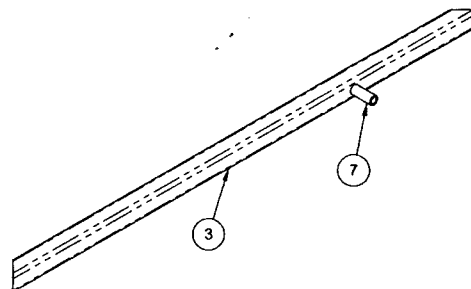
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



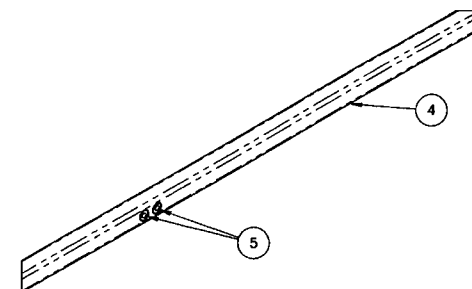
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



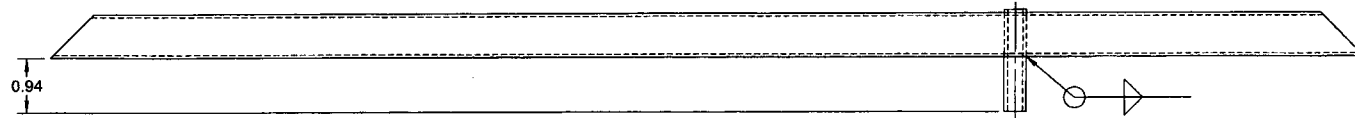
**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

1157094

REV.	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4035</b> TITLE <b>BASKET LID RIB ASSY</b>	BY	DATE
DRAWN	JPH		REV. A	SHEET 1 OF 5
CHECKED			SCALE	NTS
MFG. APPR.			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED				
DE APPR.				
DATE	10.03.04			

8 7 6 5 4 3 2 1



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL





G  
G  
TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

**RELEASED**  
2010-03-12  
W.D.

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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#57294

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D4035-5  
RIB

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

#57294

D4035-11  
BUSHING  
2 PL

G  
G  
TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

